

# Work Order ID 86476

June-29-12 1:30:21 PM

**\*86476\***

Page 1

Item ID: D4545-042

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Inner, RH (Lower)

Start Date: 29/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/29* Tooling:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4545	C								
100	Pick Kit	0.00							
<b>*1000*</b>									
Packaging	Memo	0.00							
Packaging									
110		0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AND BEND TABS AS PER DWG								
	2- DISASSEMBLE AND DEBURR								
	3- DIMPLE HOLES AS PER DWG								

*10x*

*10x*

*SB 12/02/20*

*SB 12/07/20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86476

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**\*86476\***

Page 3

Item ID: D4545-042

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Retainer, Inner, RH (Lower)

Stop **\*NS2\***

Start Date: 29/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp  
Qty Qty Number Stamp

145

0.00

**\*145\***

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AND ASSEMBLE AS PER DWG

10X *[Signature]* 12/07/11

147

QC5- Inspect part completeness to step on W/O

0.00

**\*147\***

QC

Memo

0.00

Quality Control

*SMB*  
*12.7.31*  
*DAS*  
*16*  
*2/4/11*

10

190

Identify as per dwg & Stock Location *ST 157*

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

10 *12/08/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 86476

**\*86476\***

Page 4

June-29-12 1:30:21 PM

Item ID: D4545-042

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Retainer, Inner, RH (Lower)

Stop **\*NS2\***

Start Date: 29/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

12/8/13 *[Signature]*  
R1208-2.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

June-29-12 1:30:25 PM

Page 1

**\*86476\***

**\*D4545-042\***

**Start Date:** 29/06/2012

**Required Date:** 13/07/2012

**Start Qty: 10.00**

**Required Qty: 10.00**

IPP REV:A 12.01.13 new issue DD verf:JLM

IPP REV:B

12.02.27 AS PER DWG REV.B DD VERF:EC

IPP REV:C 12.05.08

as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-2		Manufactured	No			100	Each	2.0000	1	10			
*D4541-2*													
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2		B-86442			
					81261			1		B87970			
					84959			1					
D4542-2		Manufactured	No			100	Each	2.0000	1	10			
*D4542-2*													
Retainer, Inner, RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2		B-86443			
					81266			2					
MS20426AD3-4		Purchased	No			145	Each	2,750.000	38	380			
*MS20426AD3-4*													
RIVET													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				2750					
					104374			236					
					110398			2514					
MS21059L3K		Purchased	No			145	Each	206.0000	18	180			
*MS21059L3K*													
Nutplate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST302				206					
					121114			206					

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

June-29-12 1:30:25 PM

Page 2

Work Order ID: 86476

Parent Item: D4545-042

Parent Item Name: Retainer, Inner, RH (Lower)

\*86476\*

\*D4545-042\*

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

MS21061L3K

Purchased

No

145

Each

45.0000

1

10

**\*MS21061L3K\***

NUT PLATE

\*\*

*[Handwritten signature]*  
*12/07/31*

Location

Loc Qty

Loc Code

ST303

45

120242

45

*M122459*  
*(10x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5F	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86476 MLW  
12/06/29

RELEASED  
2012-05-07  
MJP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: AFTER FORMING AND PRIOR TO ASSEMBLY, CHEMICAL CONVERSION COAT D4541-X & D4542-X PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,  
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

C	CHG FINISH (ZN A8-1); D4541-5F WAS -5 (C4-1) REMOVE TRANSFER DRILL NOTES	CP	12.04.20
B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. C SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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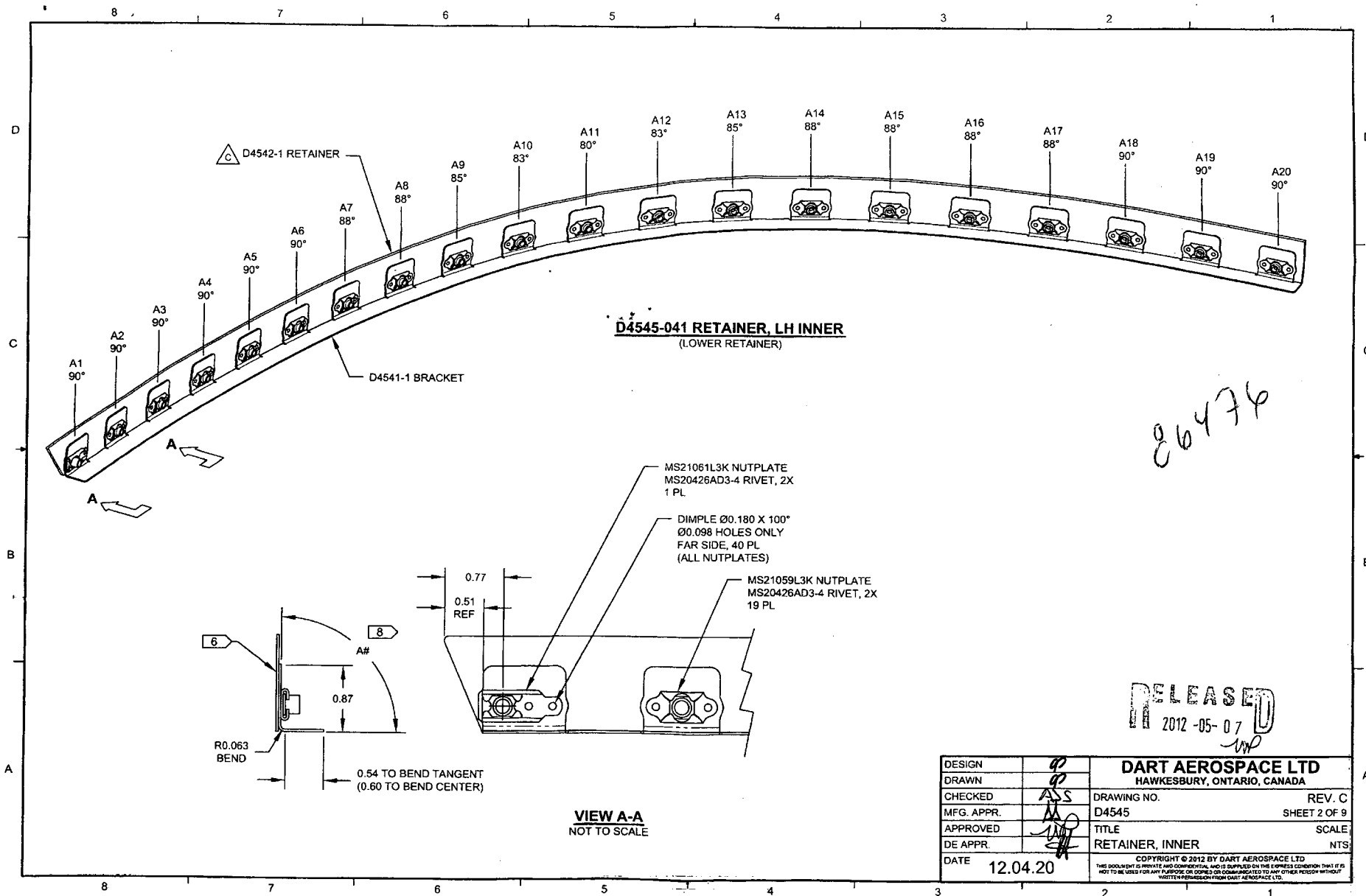
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



VIEW A-A  
NOT TO SCALE

DESIGN	gp	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	gp		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 2 OF 9
APPROVED		TITLE	SCALE
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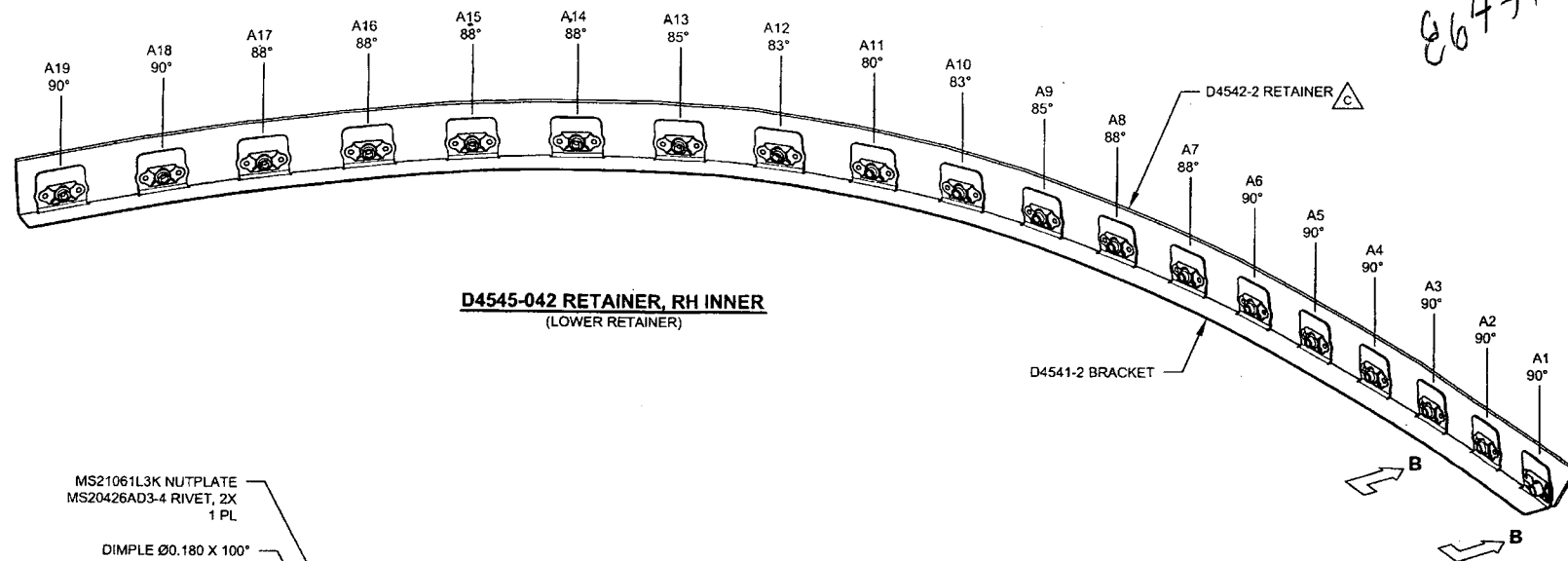
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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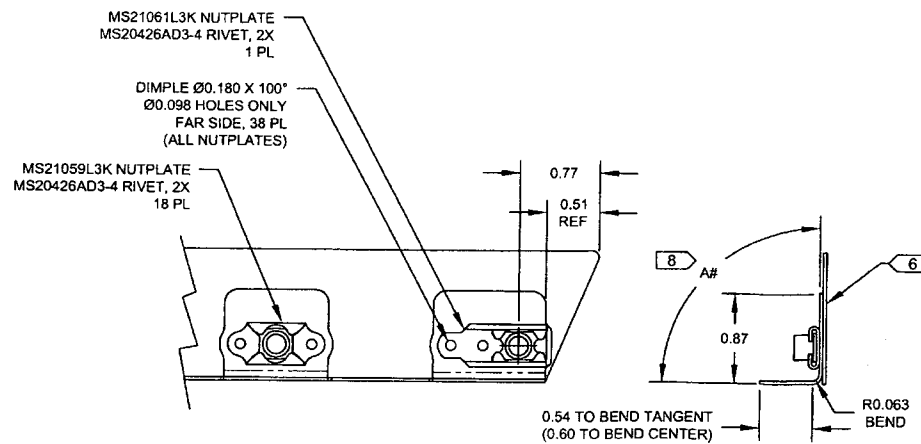
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D4545-042 RETAINER, RH INNER**  
(LOWER RETAINER)



**VIEW B-B**  
NOT TO SCALE

2012-05-07  
MP

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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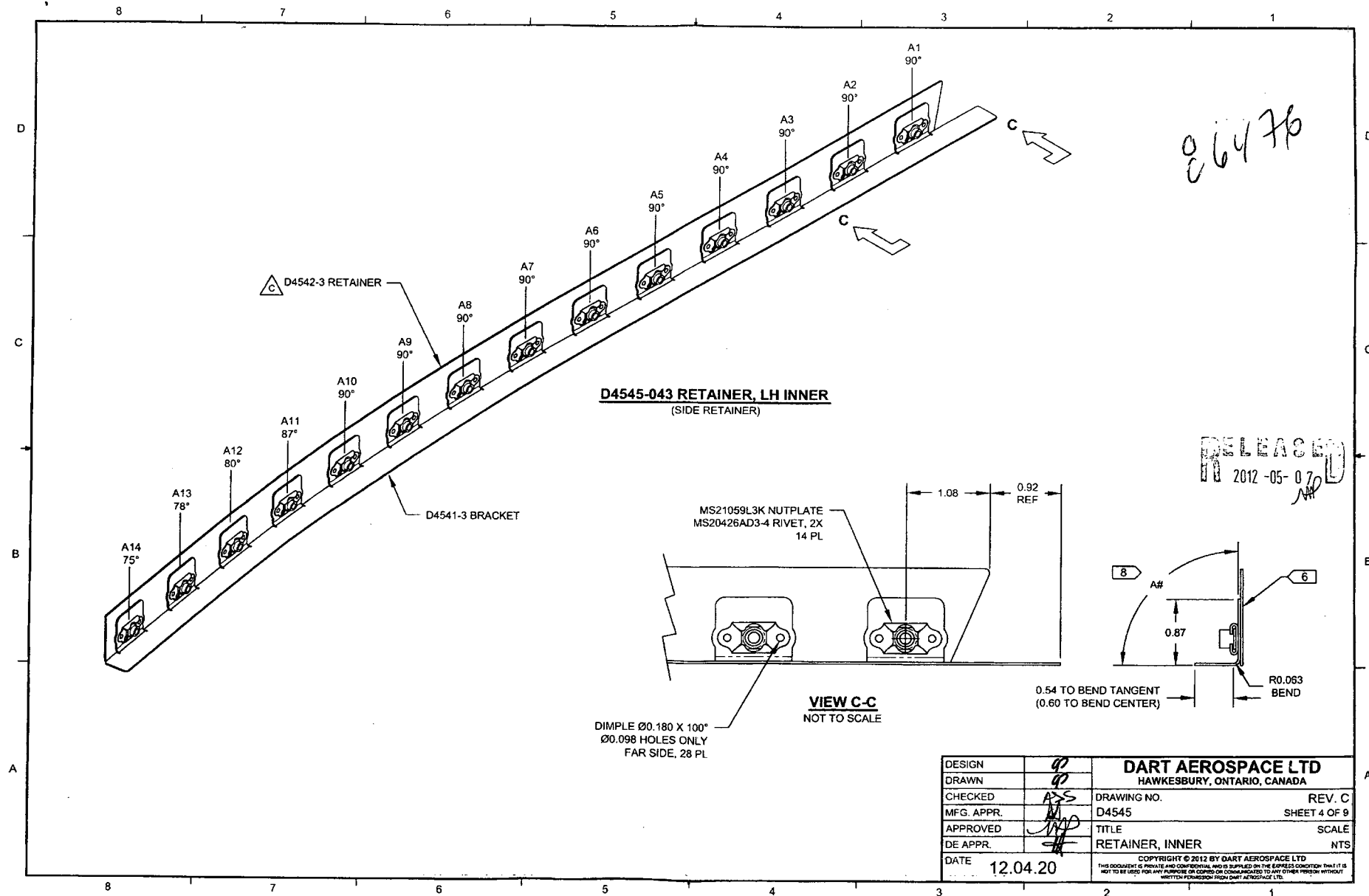
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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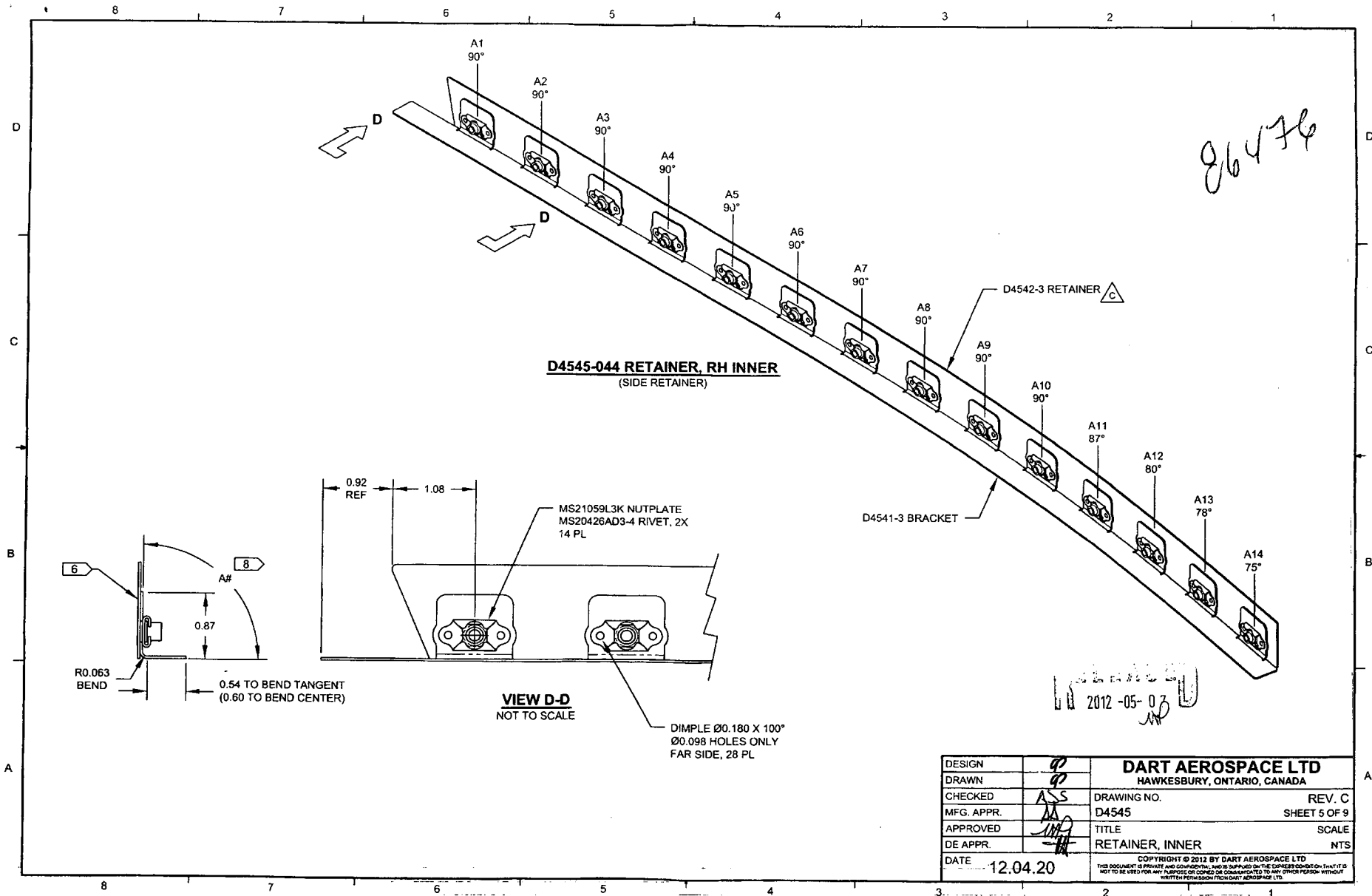
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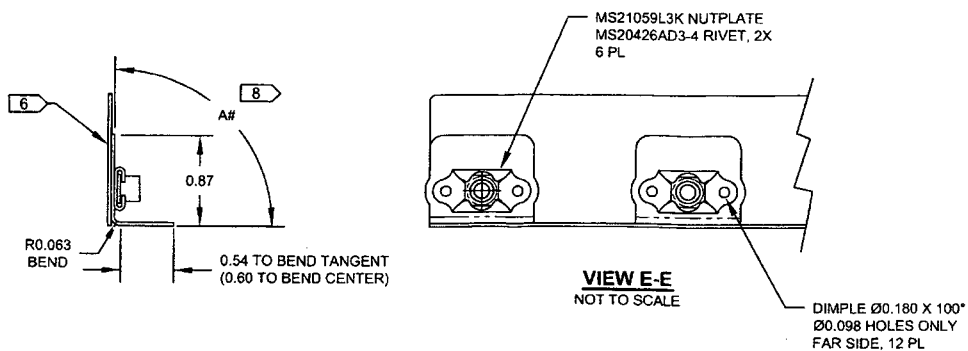
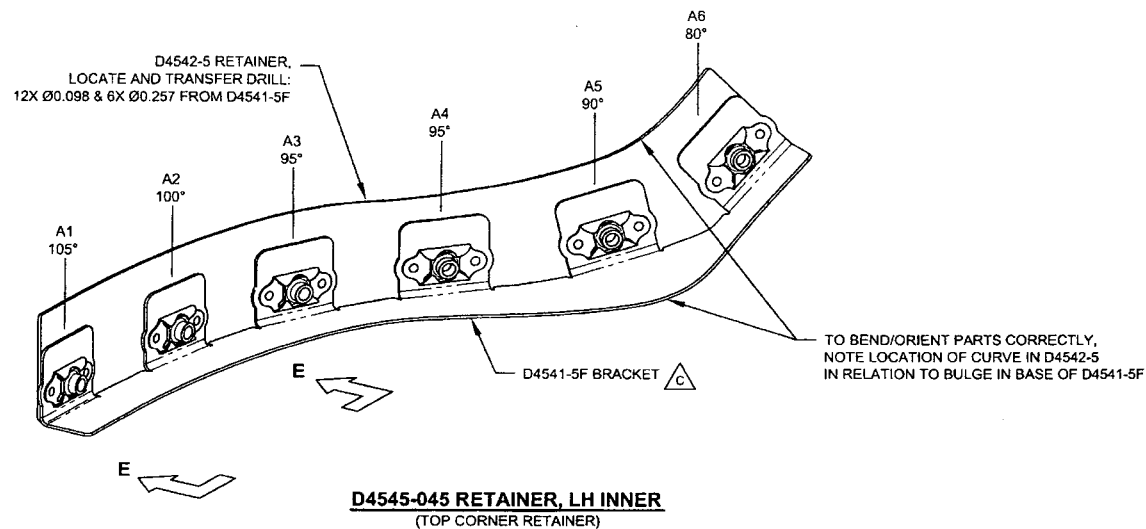
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26476



DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4545	SHEET 6 OF 9
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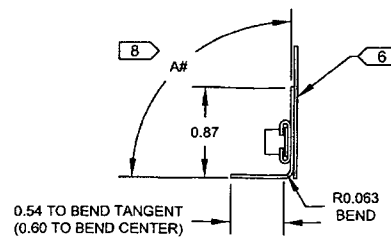
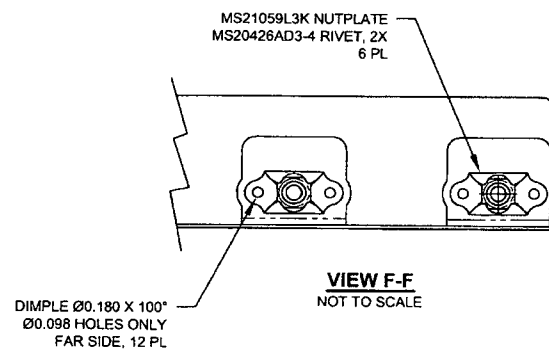
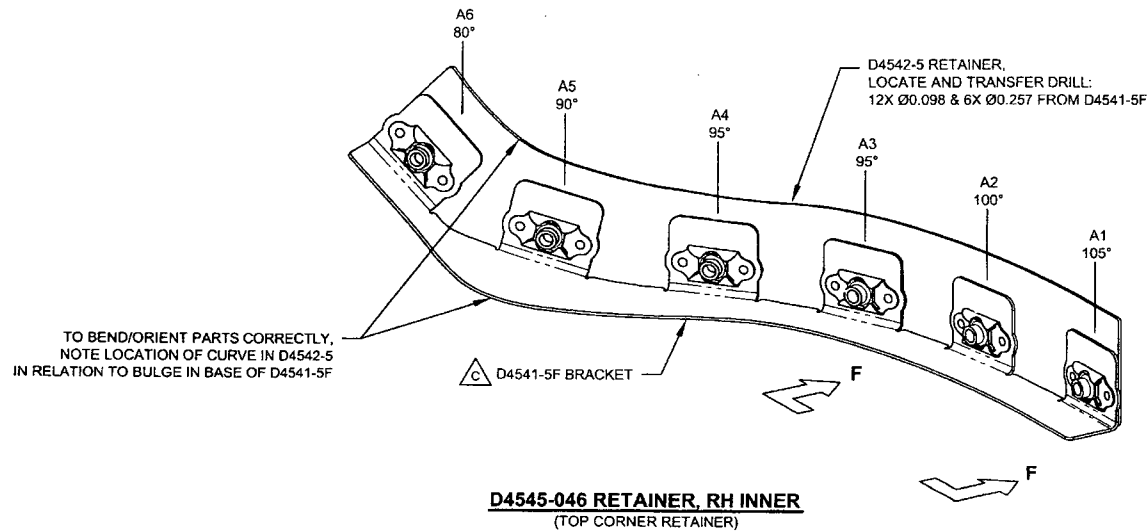
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RELEASED  
2012-05-07  
MP

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	MP	D4545	SHEET 7 OF 9
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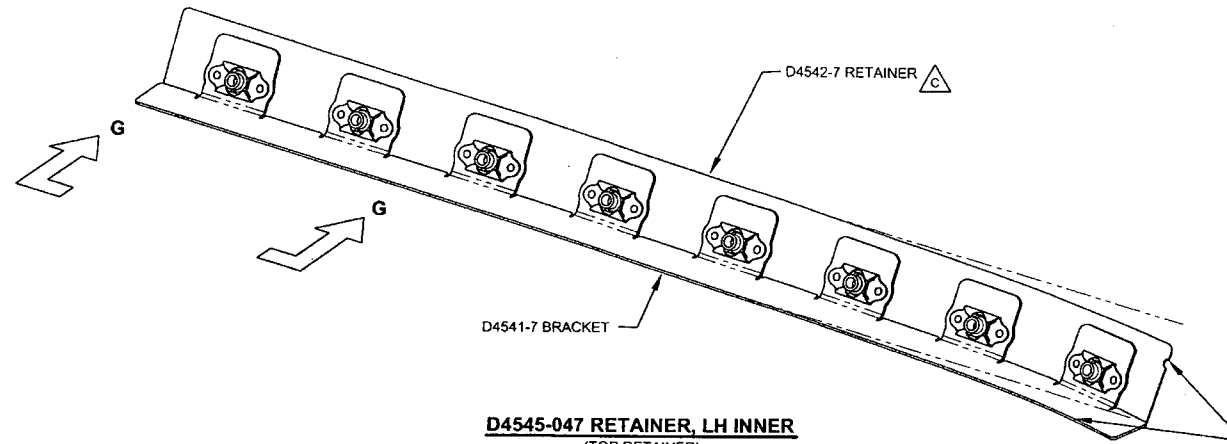
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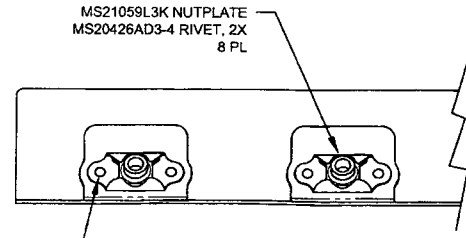
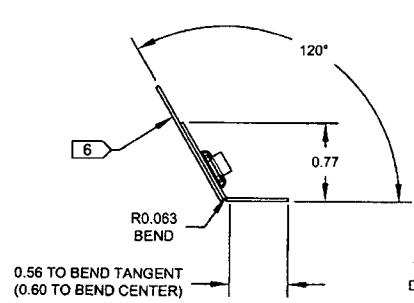




86476

**D4545-047 RETAINER, LH INNER**  
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,  
NOTE LOCATION OF TOOLING MARK IN D4542-7  
IN RELATION TO CURVE IN BASE OF D4541-7



DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL

**VIEW G-G**  
NOT TO SCALE

RELEASE  
2012-05-03

DESIGN	40	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	40		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

TO BEND/ORIENT PARTS CORRECTLY,  
NOTE LOCATION OF TOOLING MARK IN D4542-7  
IN RELATION TO CURVE IN BASE OF D4541-7

△ D4542-7 RETAINER

D4541-7 BRACKET

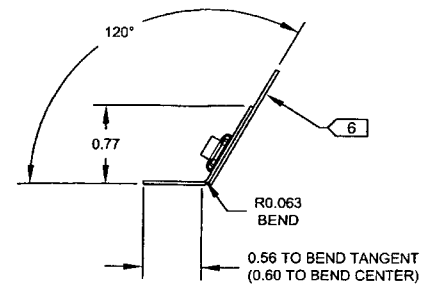
**D4545-048 RETAINER, RH INNER**  
(TOP RETAINER)

26476

MS21059L3K NUTPLATE  
MS20426AD3-4 RIVET, 2X  
8 PL

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL

**VIEW H-H**  
NOT TO SCALE



2012-05-03  
MP

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	DO	D4545	SHEET 9 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	RETAINER, INNER	NTS
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8 7 6 5 4 3 2 1

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries